

Work Order ID 76257

Tuesday, November 08, 2011 9:16:55 AM

76257

Someone by lunch A>AP

Page 1

Item ID: D2103 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 11/8/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/15/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *11-11-08* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2103	

100		0.00							
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100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<i>2024.063</i>	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
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120									
QC	Memo	0.00							
Quality Control									

Swlu/08

6

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N900040100Setup Start ***NS1***

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Item Name: Bracket

Start Date: 11/8/2011 Start Qty: 2.00

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Cust Item ID:

Required Date: 11/15/2011 Req'd Qty: 2.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Form as per dwg NC BRAKE	0.00							
130									
Brake NC	Memo	0.00		SB ulu log		(6)			
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00		S ulu log		(46)			
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

6 covered & ulu log

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/8/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 11/15/2011 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location RT No 22 0.00

0.00

180

Packaging

Packaging

Memo

0.00

6x8m 11/11/17

6 BR 11-11-17.

Box 8011-11-18

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Accept

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2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

11/11/21 11-11-18
(6)

Picklist Print

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Page 1

Work Order ID: 76257

Parent Item: D2103

Parent Item Name: Bracket

Start Date: 11/8/2011

Required Date: 11/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.03 new issuew DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	34.0000	0.01833	0.0385895		11-11-8.5	

Location

Loc Qty

Loc Code

MAT022

34

117392

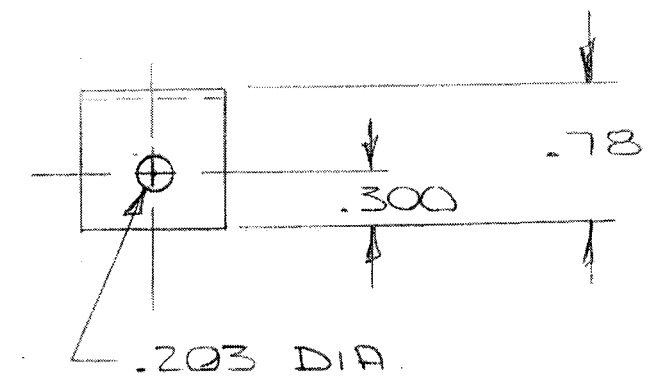
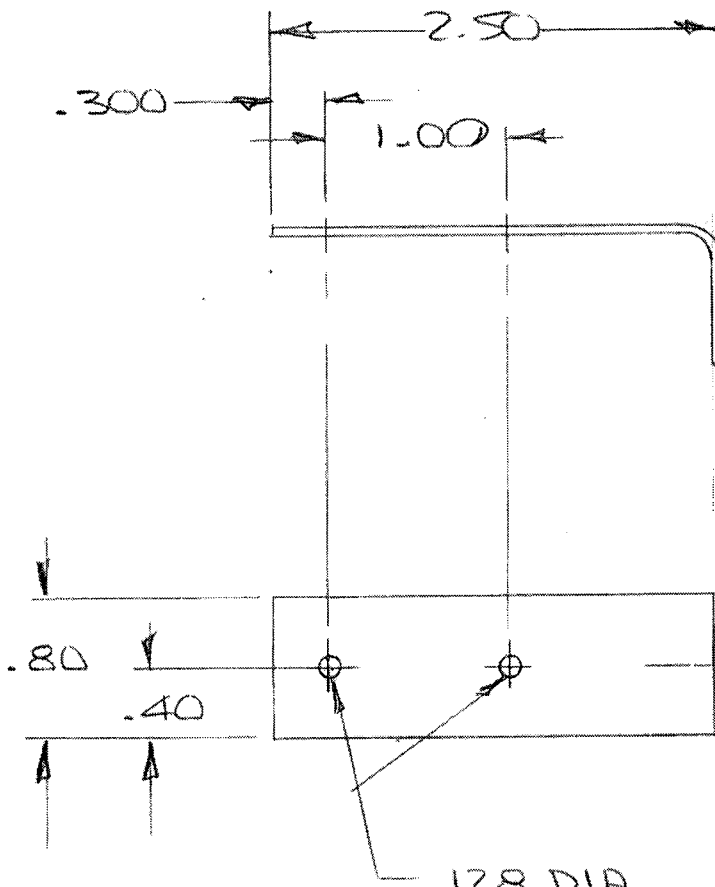
34

~~117392~~

~~34~~

117392

~~117392~~



MATERIAL:
 2024-T3 .063 THICK
 QA-A-250/4
MIN. BEND RADIUS: .188

FINISH:
 POWDER COAT
 CRINKLE BLACK

Qty 10 PER SET

76257



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENDOR	
DRAWN				BASIC CODE		DIA. DASH NO. H=HEAD NEAR SIDE F=HEAD FAR SIDE		CONTRACT NO.		DRAWN		DATE		DART AERO ACCESSORIES INC. VANCOUVER CANADA	
APPROVED				D=DRIPLE DIGIT-NO OF SHEETS C=COUNTERSINK		LENGTH DASH NO. W=SPOTWELD		DESIGNED		1492					
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES				STRESS				TITLE		BRACKET	
		GENERAL		LIMITS				CHECKED				CODE		DWG NO. D2103	
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 75/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. S. 7742 5. HOLES PER AND 10287		1. TOLERANCES — JXX ± .030 KXX ± .010 2. ANGLES 1/4" 3. PARALLELISM 1.0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005						SCALE 1:1		SHT 1 OF 1		REV.	
REPORT ALL DISCREPANCIES — DO NOT SCALE															

D2103

A